

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026801**Date Inspected:** 02-Dec-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1430**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA**CWI Name:** Chris Concha**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Maintenance Travelers**Summary of Items Observed:**

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Westmont Industries (WMI) jobsite in Santa Fe Springs, California for the purpose of observing fabrication and QC functions for the SAS Superstructure, Bid Item #99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike Path).

RPI Coating (Blast and Paint)

This QA Inspector was informed by RPI Coating Quality Control (QC) Representative Mr. Preston Keen that RPI and WMI will removing top coated elevating platforms and bike path assemblies out of the painting bay and storing assemblies outside. Mr. Keen stated that RPI will cleaning up and removing abrasive material from the paint bay prior to placing 3 more elevation platforms and 3 balconies into the paint bay for final coating applications. Mr. Keen also, stated that RPI will not be painting today.

Miscellaneous Traveler Modifications

This QA Inspector randomly observed WMI qualified welder Mr. Larry Swanson WID #3058, performing layout, fitting and tack welding on two (2) platform balconies for the SAS Traveler balcony modifications. Note: The two balconies for the SAS Travelers had been completed previously. See CCO 183 – Miscellaneous Traveler Modifications for additional information. WMI is aware that they are proceeding at their own risk pending drawing approval.

Revised Brake Mounts (Mock-up)

This QA Inspector randomly observed WMI production welder Mr. Richard Fuentes WID #3201 and one helper, performing layout, fitting and tack welding ASTM A572 Gr. 50, material 1" in thickness to trolley links

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suspension plates 2B and 3B for the Traveler Revised Brake Mounts (Mock-up). This QA Inspector observed Mr. Fuentes performing tack welding using approved Flux Core Arc Welding (FCAW) activities in all positions randomly throughout the shift.

This QA Inspector randomly observed WMI production welder Mr. Mike Ruiz (WID # 3155) welding 5/8" fillet weld joining ASTM A572 Gr. 50, material 1" in thickness to trolley links suspension plates 2B and 3B for the Traveler Revised Brake Mounts (Mock-up). This QA Inspector observed Mr. Ruiz performing Flux Core Arc Welding (FCAW) activities in the horizontal position (2F) randomly throughout the morning shift.

Traveler Mechanical Assemblies

Later in the shift this QA Inspector randomly observed WMI qualified welder Mr. Mike Ruiz (WID # 3155) performing welding activities on mechanical frames for the Maintenance Travelers Trolley Link Assembly. This QA Inspector observed Mr. Ruiz performing Flux Core Arc Welding (FCAW) activities in the horizontal position (2F) randomly throughout the mid morning shift.

SAS WB Traveler

This QA Inspector randomly observed Smith Emery, CWI, QC Inspector Mr. Chris Concha performing visual inspection on the SAS WB traveler. Mr. Concha informed this QA Inspector that he had found several areas for in process grinding and welding. This QA Inspector randomly observed WMI production welder Mr. Eutimo Lopez (WID # 3035) grinding and welding areas found Mr. Concha using Flux Core Arc Welding (FCAW) process in all positions on tube steel and plate material, randomly throughout the shift. QC visual inspection and pick-up welding not completed on this date.



Summary of Conversations:

As stated within this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910 , who represents the Office of Structural Materials for your project.

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Inspected By:	Brannon, Sherri	Quality Assurance Inspector
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Reviewed By:	Levell, Bill	QA Reviewer
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